



T H E H A R R I S P R O D U C T S G R O U P
A L I N C O L N E L E C T R I C C O M P A N Y
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TECHNICAL SPECIFICATION SHEET

ISO 9002
 Cert. No. 31598

HARRIS STAY-SILV® 5 BRAZING FILLER METAL

STATEMENT OF LIABILITY — DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. Harris Products Group. and its affiliates shall have no liability in respect thereof.

Description

Stay-Silv® 5 brazing filler metal is a frequent choice for brazing copper. It has a wide melting range which allows the operator to fill loose connections. It can be used to braze brass with the use of Stay-Silv® white brazing flux. Stay-Silv® 5 is not recommended for brazing steel or other ferrous metals.

NOMINAL CHEMICAL COMPOSITION:

Silver	4.8-5.2 %
Phosphorus	5.8-6.2%
Copper	Balance
Other Totals	.15 % max

PHYSICAL PROPERTIES:

Solidus	1190°F (643°C)	Electrical Conductivity	9.6
Liquidus	1494 -1506°F (812-819°C)	Electrical Resistivity	18.1
Brazing Temperature Range	1320 - 1500°F (716 - 816°C)		
Specific Gravity	8.14		

Available forms

Standard wire and rod diameters and formed rings.

Specification Compliance

ANSI/AWS A5.8 Class BCuP-3, ASME SFA 5.8 Class BCuP-3, QQ-B-650C Class BCuP-3.

Recommended Flux

No flux required for copper to copper connections. Stay-Silv® white brazing flux for brass or bronze.

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

ARC RAYS can injure eyes and burn skin.

ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

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Additional information available at our web site: www.harrisproductsgroup.com

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